



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-100
Job Sheet 178813



Part No: SWA25A-100

Job Qty: 10 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A-100 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/15/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	10 pcs		6/15/18	0.00	10.00	MORI NLX		
120	QC	10 pcs		6/15/18	0.00	0.00	QC2		
130	QC	10 pcs		6/15/18	0.00	0.00	QC8		
140	Packaging	10 pcs		6/15/18	0.00	0.00	Packaging3		
150	QC21-SA	10 Ea		6/15/18	0.00	0.00	QC21		

Part Op 110 - Cut Blanks AT 7.00" 1-Machine as per DWG. FB901 FOLIO REV: _____ DWG REV: _____
Descriptions: 2-Deburr 3-2-***Please see PEC to change engraving batch # for every w/o***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.000	17-4 H1150 Round Bar 3.000"	5.8300 ft (.583 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R3.000	6	13	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 3:25 PM dart.lajeunesse.marie



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CANADA
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Container No: S082250



Part: SWA25A-100

Job No: 178813

Serial No/Batch: S082250

Revision: 6

Inspector:

Exp Date:

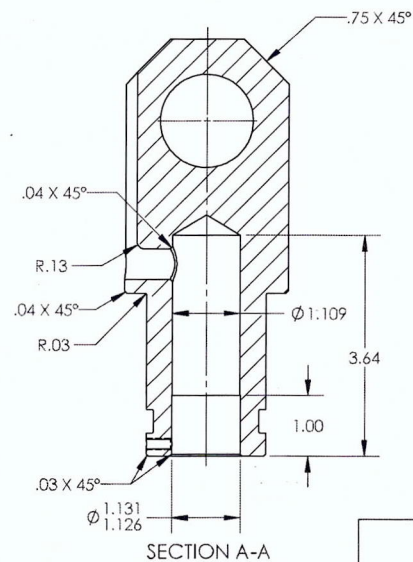
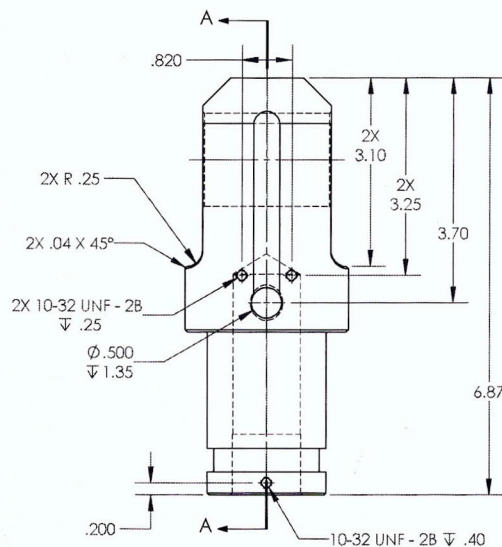
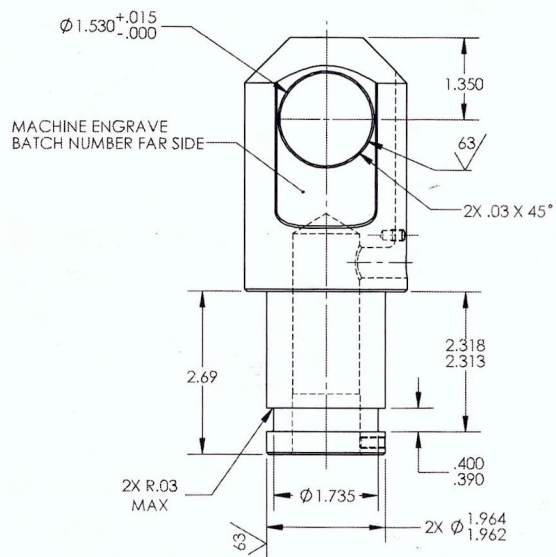
Instructions:

Date: 06/19/18

Technical drawing of a circular part with the following dimensions:

- Outer diameter: 2.125
- Inner diameter: $\phi 2.70$
- Radius: R.22
- Slot width: .434
- Slot depth: 1.150

HIDDEN LINES
REMOVED FOR CLARITY



REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
5		AS DRAWN BY CANAM.	11/12/2012	JAG		
5A		CHD B/O TO SWA10A-100 BLANK.	5/1/2014	JAG	RW	
6	16-0275	UPDATED TO NEW STANDARDS. ADDED NOTE "ENGRAVE BATCH NUMBER". CHD MAT'L WAS SS 17-4, H1150 E SS 17-4 H1150/H1075. CHD DIM WAS 3.100 E 2X 3.10. ADDED DIM 2.69, 2X3.03 MAX, Ø1.735, 2.310/Ø.315, 400/390, 2X Ø1.964/1.965, 6.87, Ø4.459, F.03, .03 X .459, Ø1.131/1.126, 1.01, Ø1.109, 3.64, Ø2.70, 75 X 45. REMOVED DIM 1.370.	12/29/2016	SM	JAG	



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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178813 MCT

18-06-08

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OF SPECIFICATIONS
			SWA25A-100	1	LOWER END	SS 17-4 H1150/17-4 H1075	

		REV 6	
		TITLE LOWER END	
DWG NO.		SWA25A-100	
MAT'L SS 17-4 H115017-4 H1075 REAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/16 .XX ± .01 ANGLES ±.5° .X ± .1 SURFACES = 125/	
DRAWN BY: CANAM CHECKED: CLOUGH DQPS APPR: ANDERSON. QA APPR: LINDSAY APPROVED: GILBERT		1. BREAK ALL SHARP EDGES .015 X .45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5-2009 USED ON MODEL	
SCALE	1:2	DATE	1/22/2002
		SHEET 1 OF 1	

DART AEROSPACE LTD		Work Order: 178813
Description: Lower End		Part Number: 102-050
Inspection Dwg: SWA25A-100	Rev: C ₂	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	+0.015 / -0.000	1.533				
1.350	±0.005	1.3505			H.G	
Ø3x45°	+/-0.01 x .5°	Ø3x45°			Vern LPO9	
2.69	±0.01	2.690			H.G	
1.735	±0.005	1.735			Mic LPO2	
1.963	±0.001	1.963			↓	
.395	±0.005	.395			Vern LPO9	
2.3155	±0.0025	2.315			OPT Comp	
Ø2.70	±0.01	2.700			Mic LPO3	
2.125	±0.005	2.1235			↓	
.434	±0.005	.433			Vern LPO8	
R.22	±0.01	.2188			R.G.	
R.25	±0.01	.250			↓	
.820	±0.005	.823			Vern LPO9	
.25	±0.01	.250			↓	
Ø4x45°	±0.01 x .5°	Ø4x45°			↓	
10-32unF-2B	GO-NOT GO	GO			↓	
.25	±0.01	.240			↓	
Ø.500	±0.005	.499			Gage Pin	
1.35	±0.01	1.35			Vern LPO9	
.200	±0.005	.200			H.G	
3.10	±0.01	3.100			H.G	
3.25	±0.01	3.250			↓	
3.70	±0.01	3.701			↓	
6.87	±0.01	6.8689			↓	
R.13	±0.01	.125			Vern LPO9	
Ø4x45°	±0.01 x .5°	Ø4x45°			↓	
R.03	±0.01	.032			↓	
Ø3x45°	±0.01 x .5°	Ø3x45°			↓	

Measured by: P	Checked by: [Signature]	QC Inspector:
Date: 18-06-20	Date: 18/06/25	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

